

Date: Friday, 23/05/2008 8:25:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR ARM
 Job Number : 39431
 Estimate Number : 10335
 P.O. Number :
 This Issue : 23/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2010104
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D2010 REV. C2
 Previous Run : 39208 Material :
 Written By : Due Date : 30/05/2008 Qty: Um: Each
 Checked & Approved By :
 Comment : Est A 04.02.17 New issue KJ/JLM

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s)
 Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall
 (M304TR0500W035) 049 Batch No: M107518

SEE ATTACHED
SB 08/05/23

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC
 Punch per Dwg. D2010-104 and Spec Control Dwg D2727
 Identify as D2010-104

SB 08/05/23

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Bend as per Dwg D2010 using bending Jig D2010-104T2
 2- Debur

①
FF 08-05-26

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Plug
 batch: B39432

①
FF 08-05-26

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- flare before installing plug as per dwg D2010
 2- Install D2057 plug as per Dwg D2010

①
FF 08-05-26

Dart Aerospace Ltd

WIO: 39431-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-05-23	1	USE M304TRUS00W049 Tubing instead of 0.500 x 0.035 wall PERMANENT CHANGE	RA	08-05-23	ALL	RA 08/05/23 SEE ATTACHE	08/05/23

Part No: D2010-104 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39431

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/26 (X)

7.0

POWDER COATING

POWDER COATING



M105642



(IX)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

320 °C

FINISH TIME:

12:00

M. J.

08/05/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08.05.27

(XI)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/05/27 (I)

POSITIVE RECALL

EFFECTIVE 08/05/23

AUTH 4

RELEASED 11

DATE 08/05/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



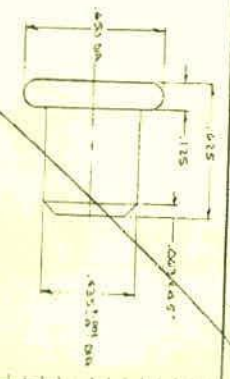
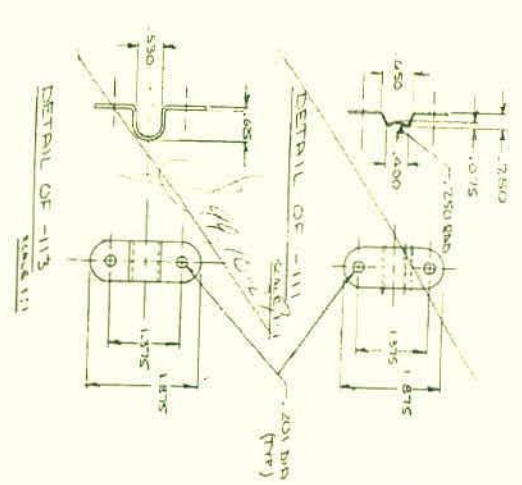
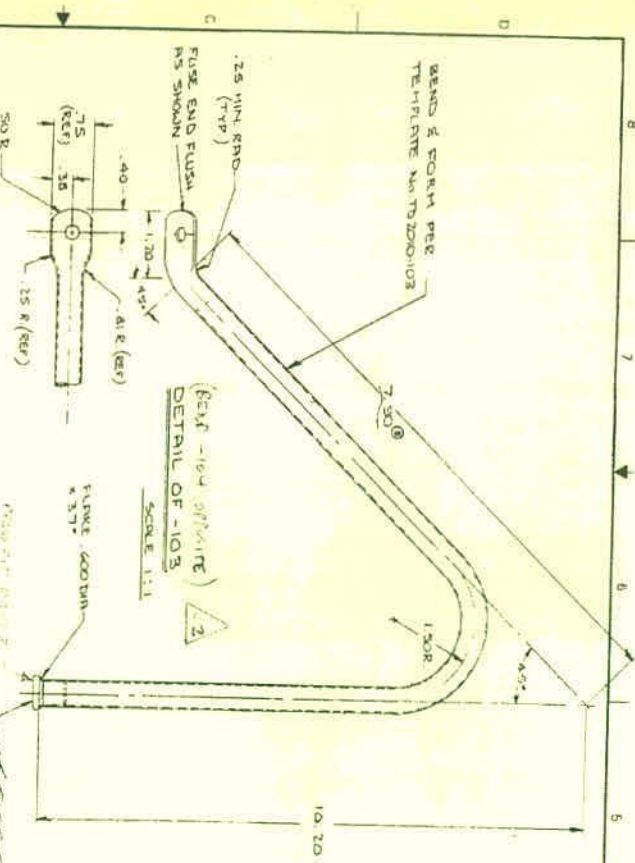
Comment: FINAL INSPECTION/W/O RELEASE

08/05/27 (X)

Job Completion



08/05/27



DETAIL OF 109
SCALE 4:1
Approved by D2057 150 B
EE 9/17/16 1584/229

GENERAL NOTES:

1. MINIMUM RADIUS FOR 2024-T3
0.03 THICK IS 1/8"
2. PAINT -01 MATTE BLACK
3. FINE 304 STAINLESS STEEL MAY
BE SUBSTITUTED WITH TYPE 302
OR 316
4. 2024-T3 MAY BE SUBSTITUTED
WITH 2024-T1 CLAD (20-40%
FIBER REINFORCED CARBON FIBER)
IF FIBER REINFORCED CARBON FIBER
IS 0.03-0.05 (GRT 4)
5. IN PLACE FOR PER
INSTALLATION
INSTRUCTIONS.

[illegible][illegible]

FILL IN HERE - USE INK, PRINT NAME, LAST FIRST	
DATE	
1. NAME	LAST FIRST
2. GRADE	1 2 3 4 5 6 7 8 9 10 11 12
3. SCHOOL	NAME
4. CITY	STATE
5. ZIP CODE	ZIP CODE
6. PHONE	PHONE
7. E-MAIL	E-MAIL
8. SIGNATURE	SIGNATURE
9. DATE	DATE
10. NAME	NAME
11. GRADE	GRADE
12. SCHOOL	SCHOOL
13. CITY	CITY
14. STATE	STATE
15. ZIP CODE	ZIP CODE
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17. E-MAIL	E-MAIL
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19. DATE	DATE
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157. E-MAIL	E-MAIL
158. SIGNATURE	SIGNATURE
159. DATE	DATE
160. NAME	NAME

[illegible][illegible][illegible]

DATE	02/27/13	COUNT	001
DESCRIPTION	PARCEL	UNIT	000000
PARCEL PARCEL IDENTIFICATION NUMBER 0000000000 CANADA			
WAREHOUSE BACKSET DETAILS D2010			

~~0.049~~
0.049
14
Q23 011
01.05.23

